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(54) **WIRE FOR PRESSURE RING, PRESSURE RING  
AND METHOD OF MAKING THE SAME**

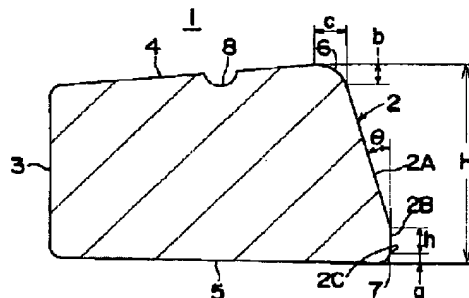
4, serving as an upper surface of the ring, is formed  
with a recessed groove 8 along the longitudinal direction.

(57) Abstract:

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PROBLEM TO BE SOLVED: To prevent generation of chips or the like at coiling times or the like of a wire for a pressure ring, facilitate discrimination of the upper/lower in two surfaces which serve as the upper/lower surface of a ring in the wire for the pressure ring, and to provide a method of making the pressure ring using the wire for the pressure ring and the pressure ring of high performance at a low cost.

SOLUTION: A surface 2, serving as the external peripheral surface of a ring of a wire 1, is formed with a tapered surface 2A, a flat surface 2B, and an end part outside protrusion preventing surface 2C. The end part outside protrusion preventing surface 2C is recessed to the side of a surface 3 serving as an internal peripheral surface of the ring from the flat surface 2B. The width of the flat surface 2B is 0.05 to 0.3 mm, and the tilt angle of the tapered surface 2A is 0.5 to 5°. The upper/lower angular part of the surface 2 serving as the external peripheral surface of the ring in the wire 1 is formed chamfered, the chamfer 6 on the upper side is larger than the chamfer 7 on the lower side. A surface



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